

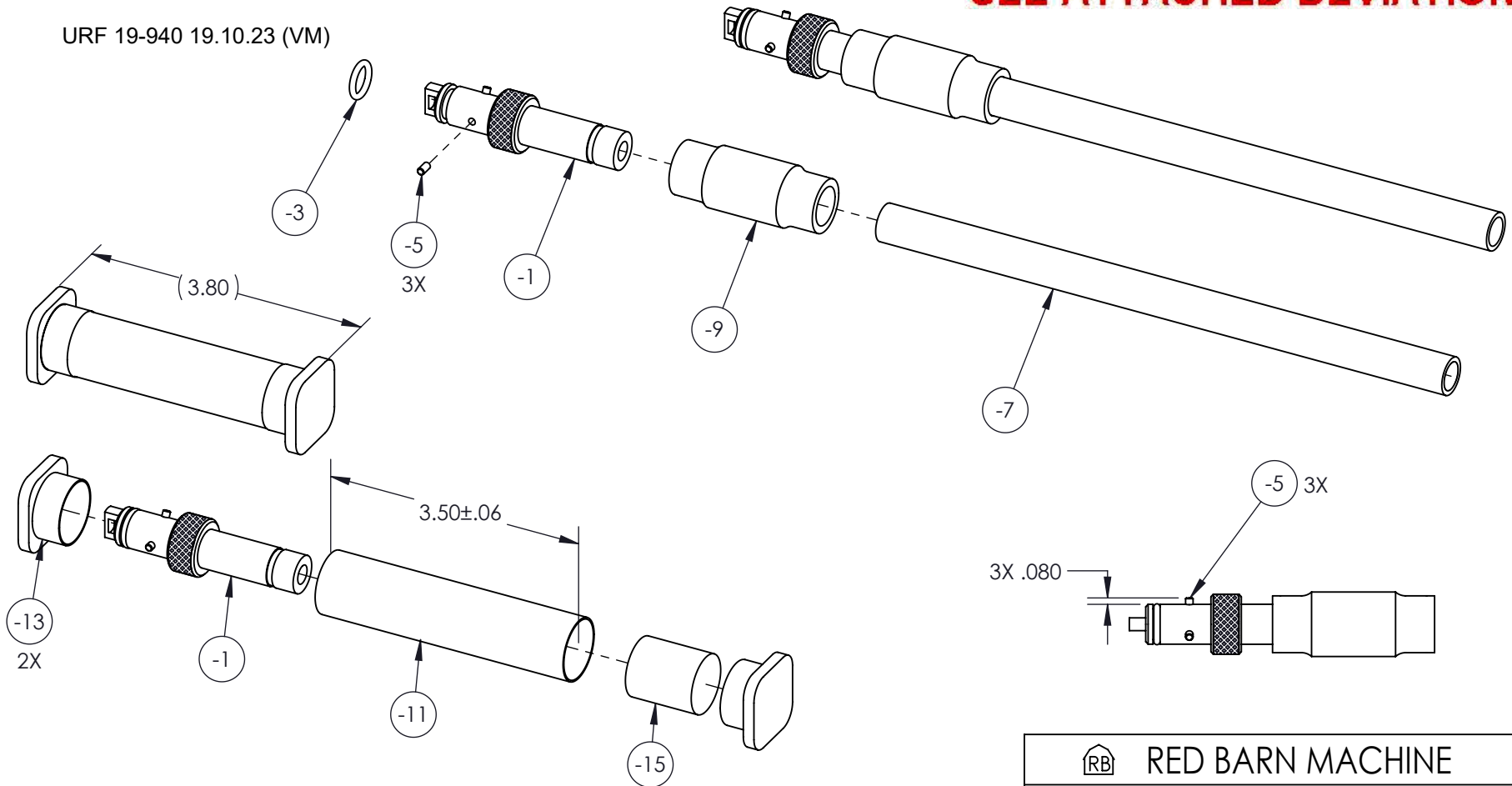
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CORRECTED -1 Ø.402 CYLINDRICAL FEATURE PER G.E.	5/9/2011	RJC	RW
1	MODIFIED -1 TO WORK WITH COUPLING, ADDED COUPLING, DELETED CRIMP HOSE CLAMP AND HEAT SHRINK. ADDED -11, -13, -15, EXPLODED VIEWS, AND UPDATED BOM.	7/27/2012	JAG	
1A	-11 CH'D DIM WAS 3.60 IS 3.50. -15 CH'D MATERIAL TO NEW PIG CORP. #PAD210. -1 CH'D Ø.750 TO REFERENCE. CH'D DIM WAS Ø.250±2.700 IS Ø.250±2.70 MAX.	2/5/2014	DPD	RW

UNDER REVIEW

URF 19-940 19.10.23 (VM)

SEE ATTACHED DEVIATION



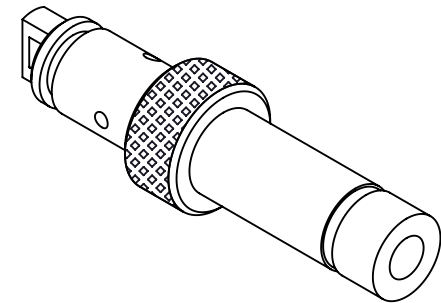
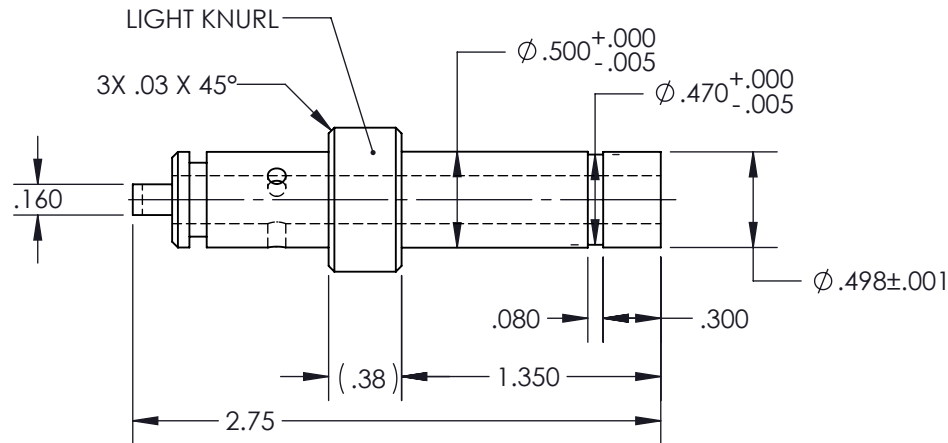
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	Ø3/4 X 2-7/8	2
		B/O	-3	1	O-RING	VITON	Ø13mm OD x 2mm WIDTH MCMaster-CARR #9263K173	1
		B/O	-5	3	DOWEL PIN	S.S.	Ø3/32 X 3/16 MCMaster-CARR #90145A433	1
		B/O	-7	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-9	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMaster-CARR #51495K116	1
		B/O	-11	1	TUBE	POLYETHYENE	Ø.79 MCMaster-CARR #2044T45	1
		B/O	-13	2	CAP	VINYL	Ø.79 MCMaster-CARR #2044T65	1
		B/O	-15	1	FOAM	POLYESTER/POLYURETHANE	Ø3/4 X 1 NEW PIG CORP. #PAD210	1

RED BARN MACHINE	
TITLE	
MAIN TRANS. DRAIN TOOL	
DWG NO.	RBH9807
REV	1A
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	FINISH
SCALE 1:2	SPEC
DATE 12/9/2010	USED ON MODEL
SHEET 1 OF 2	MD500

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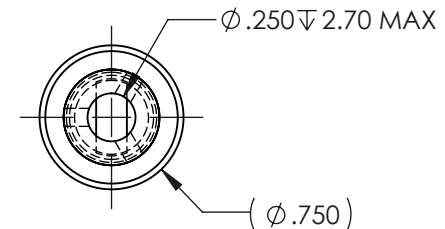
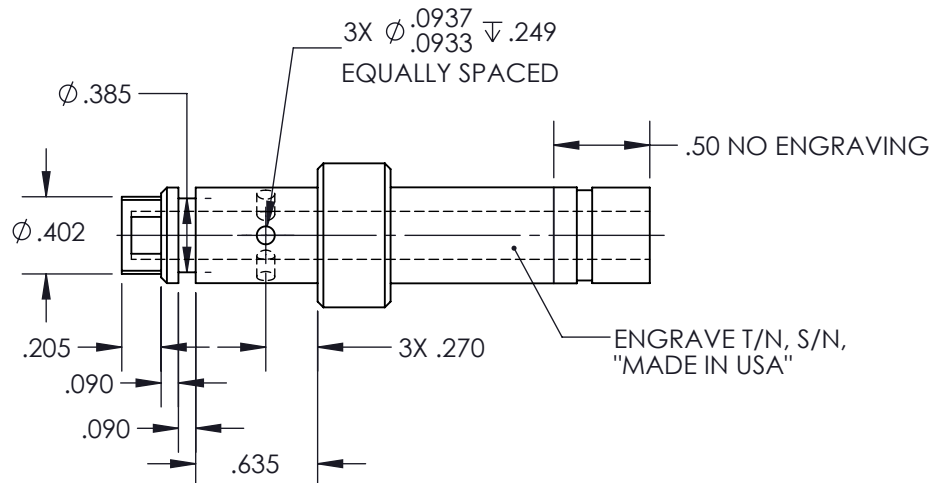
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CORRECTED -1 Ø.402 CYLINDRICAL FEATURE PER G.E.	5/9/2011	RJC	RW
1	INCREASED LENGHT OF STEM FROM .800 TO 1.35, REMOVED BARB AND ADDED GROOVE	7/27/2012	JAG	
1A	-1 CH'D Ø.750 TO REFERENCE. CH'D DIM WAS Ø.250±2.700 IS Ø.250±2.70 MAX.	2/11/2014	DPD	RW

**SEE ATTACHED DEVIATION**



**UNDER REVIEW**

URF 19-940 19.10.23 (VM)



(-1)  
QUILL

<b>RED BARN MACHINE</b>	
TITLE <b>MAIN TRANS. DRAIN TOOL</b>	
DWG NO. <b>RBH9807-1</b>	REV <b>1A</b>
MAT'L 6061	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH RED ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	MD 500
SCALE 1:1	DATE 12/9/2010
SHEET 2 OF 2	

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. <u>RBH9807 Rev. 1a</u>	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>		
Date :	Sequence #:	QTY Affected :	<b>MRB (QSI042)</b>  Oct 30, 2018	
<b>Description Work Order Deviation</b>		<b>Disposition</b>		<b>Completed By</b>
Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116)		Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush.  Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).  This deviation is acceptable.  The fit, form and function of the part will be as originally intended.		<b>Lead hand / Supervisor</b> JRF 19-940 1
				<b>QC / QA Coordinator</b> J10.23 (VM)
<b>Root Cause</b>		<b>FAULT CATEGORY</b>		
<div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input checked="" type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		<div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>		
		Other/Details:		

UNDER REVIEW